



AMENDMENTS TO THE SPECIFICATION:

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Replace the title on line 1 of page 1 with the following amended title:

DRYWALL BEAD WITH KNURLED PAPER FLAPS AND
METHOD OF MAKING SAME

On page 1, please add the following paragraph after the title as follows:

CROSS-REFERENCE TO RELATED APPLICATION

15' This application is a continuation-in-part of application no. 29/145,604, filed July 25, 2001, now issued as U.S. Patent No. D457,972.

Replace the paragraph beginning at line 7 of page 1 in its entirety with the following amended paragraph:

152 Building construction over the years has typically involved framing to form a framework of vertical studs and cross members. Previously it was known to cover the studs with vertically spaced apart, horizontal slats, known as lath, and ~~then to~~ to then cover such slats with plaster troweled in place by a craftsman to provide a smoother finish. Plaster finishing was a very demanding task requiring skill and experience. While enjoying popularity, it was believed there were problems of one lath and plaster wall[[s]] shifting relative to another thus cracking along the joint and creating irregularities in the product. In recognition of the perceived problem, various types of corner fittings were

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proposed, including a rolled metal expansion strip having a pair of orthogonal metal flanges formed with respective ~~a pair of~~ separator ribs radiating outwardly at 90° to one another to form cylindrical rolls defining a channel therebetween and having their respective outer extents disposed at what will be the outer surface of the plaster layer, so that the outer surface of Thus, plaster trapped therebetween when troweled [[,]] will form a separate vertical bar and, evenly into the ribs will form a 45° corner surface. ~~finish~~ chamfer. The vertical strip of plaster trapped between the ribs is then separated from that covering the lath in the adjacent walls and the rolls are free to expand and contract. An expansion device of this type is shown in the 1934 U.S. Patent No. 2,012,203 to Peterson. It was contemplated that this expansion bead was to be nailed in place on the lath construction. To my knowledge such a device never gained broad acceptance in the lath and plaster construction field, and is not adopted to use as a tape or bead for drywall construction. ~~Absent the nail holes imparted on the metal flange, there is no means for anchoring the fitting to joint compound on the interior of the fitting so as to, when cured, anchor the fitting firmly in place.~~

Replace the paragraph beginning at line 8 of page 4 in its entirety with the following amended paragraph:

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To enhance the function and finished appearance of such drywall corner beads, a covering of some other material such as paper or fabric has been employed. The challenge is to provide such an exterior covering that is substantial enough to secure the inner core in position while being thin enough to create a smooth transition between the

cover and the underlying drywall. One bead developed to address some of the problems with the prior art is a corner bead with a metal core, covered on its exterior with a paper cover which projects beyond the opposite lateral edges to form flexible flaps. Such flaps, projecting beyond the edges of the flanges, can serve to form a smooth transition over such edges, and have been proposed to anchor the bead in joint compound applied thereunder. These beads are typically referred to as tape-on beads. Stock paper had the advantage that frayed fiber ends would facilitate adherence to the joint compound as it ~~covered~~ cured. The problem was that ~~the frayed ends would project outwardly from the outer surface and would,~~ upon sanding to finish joint compound applied thereover, the frayed ends could be contacted and raised to project through the compound producing an unsightly surface. By impregnating the paper ~~throughout~~ with latex it was believed that the fraying could be reduced and the paper strengthened. It was proposed that the core be covered with wallboard grade paper and that it be impregnated with latex to make the paper resistant to scuffing and such fraying. ~~It was perceived that this construction exhibited poor joint compound bonding properties, thus subjecting it to unwanted peeling.~~ Devices of this type are shown in U.S. Patent Nos. 5,613,335 and 5,836,122, both to Rennich. It was perceived that this construction exhibited poor joint compound bonding properties, thus subjecting it to unwanted peeling. In effort to improve bonding properties, it was proposed to construct a tape-on bead covered with a stock paper having a high resistance to abrasion, such as the backing used in commercial grade commercially available sandpaper. It was perceived that any deficiency in bonding could be overcome by abrading the surface of the conventional

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paper flaps to loosen the surface fiber in effort to improve the bonding to the surface of the wallboard. A bead of this type is shown in U.S. Patent No. 6,295,776 to Kunz. Kunz utilized conventional flaps projecting from the opposite sides and formed with small holes to be covered with joint compounds. ~~In effort to improve the strength of bond to the joint compound, the flat flaps were formed with small holes so compound applied to the exterior would flow through.~~ While such fraying of the fibers may, in fact, serve to resist peeling, experience has shown that the flat frayed flaps bead that Kunz proposed, a drywall fitting with a classic raised bead at the juncture between its two flanges to serve as a straight edge for application of compound to the exterior of the flanges. even with compound in the holes can pull loose. As noted in U.S. Patent No. 6,539,680 to Kunz permanent deformation of the paper wings can be beneficial for improving performance of the joint to which the bead is attached. In any event, until now craftsmen have been forced to select between nail-on or ~~fitting which are time consuming to install or~~ tape-on fittings having flat paper flaps which often do not bond well into the compound thereby being susceptible to pulling free from the cured joint with only minimal forces being applied thereto.

It has been common practice to apply joint compound, often referred to in the field as mud, to the interior surfaces of the core and the flanges prior to installation on a drywall corner. This compound then acts as an adhesive to help hold the bead temporarily in place while it is nailed or compound is applied to paper flaps and is available to flow through holes in the flanges or to adhere to the interior surfaces of paper flaps.